

Work Order ID 85905

85905

Page 1

June-18-12 2:28:50 PM

Item ID: D3443-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Weldment Assembly

Start Date: 18/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18 Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3443								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

⑥ 12-9-25

DAS 24 12-9-25

6x

Smr 12-9-25

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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N900040100

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Revision ID:

Item Name: Strut Weldment Assembly

Stop

NS2

Start Date: 18/06/2012 Start Qty: 4.00

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Cust Item ID:

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

1-Mask holes as per dwg D3443

START TIME: 12:00

OVEN TEMPERATURE: 400 OF

FINISH TIME: 12:30

0.00

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

150

Small Fab

0.00

150

Small Fab

Small Fab

Memo

Assemble bearing and ball plungers as per dwg D3443 using DT9518

Ensure bearing rotates smoothly

0.00

6X4

12/09/26

345

6φ

12-9-26

6x

12/09/27

W122878

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 Smb 12/9/12	DAS 16	12/09/12		6			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>21 485</u> Memo	0.00 0.00				6		12/09/28/13	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/10/11 [Signature] MF 12-10-01

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NOTE: Date & initial all entries

Picklist Print

June-18-12 2:28:54 PM

Page 1

Work Order ID: 85905

85905

Parent Item: D3443-041

D3443-041

Parent Item Name: Strut Weldment Assembly

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3443-1		Manufactured	No			100	Each	0.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3443-1

75188x6

**

12-9-24

Lug

D3443-5		Manufactured	No			100	Each	2.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3443-5

**

12-9-24

Tubing

86906x6

Location

Loc Qty

Loc Code

WA030

2

78203

2

D3453-1		Manufactured	No			100	Each	6.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3453-1

**

12-9-24

Clevis

Location

Loc Qty

Loc Code

WA

6

80246

6

D3965-4		Manufactured	No			100	Each	0.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3965-4

388528 2x

378208 2x

**

12/09/27

Bearing, Spherical

D3966-4-750		Manufactured	No			100	Each	25.0000	2	8			
-------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3966-4-750

**

12-9-24

Pin, Dowel

Location

Loc Qty

Loc Code

ST079

25

73566

25

88575 x 12

W/O:		WORK ORDER CHANGES					
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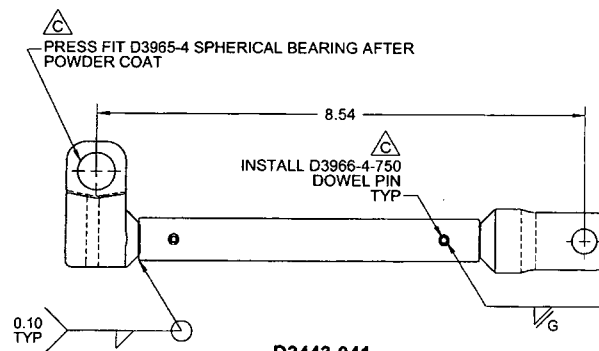
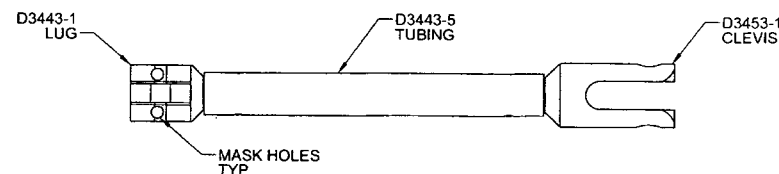
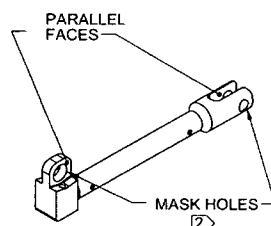
NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85905 ML5
12/06/18

RELEASED
09/06/25 MP



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUR P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3443

REV. C
SHEET 1 OF 4

TITLE
STRUT WELDMENT ASSEMBLY

SCALE
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

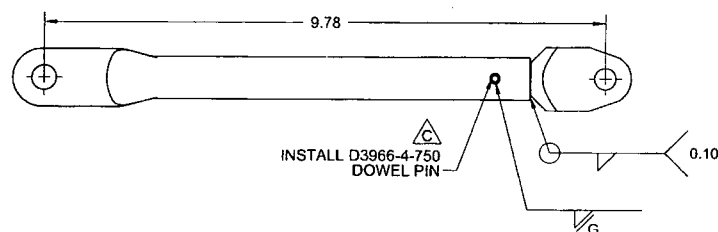
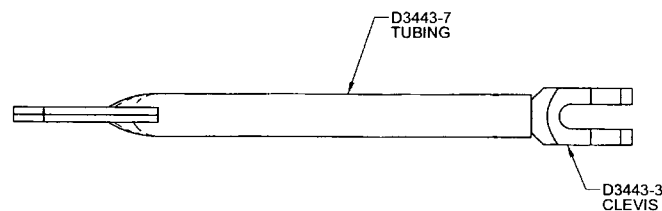
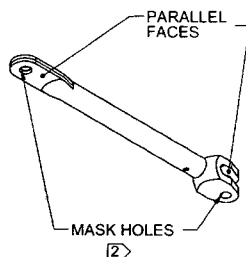
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3443	REV. C
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE STRUT WELDMENT ASSEMBLY	SCALE NTS
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DATE	09.06.25		

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09/06/25

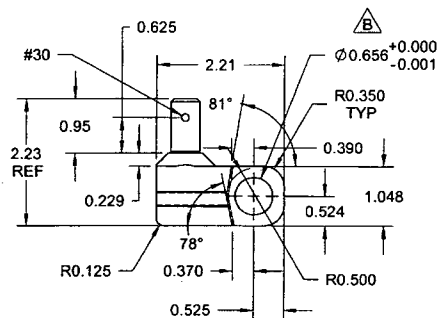
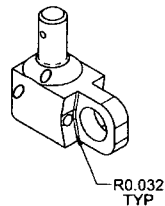
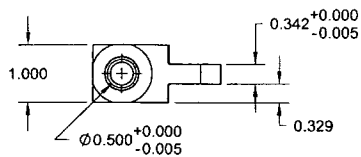
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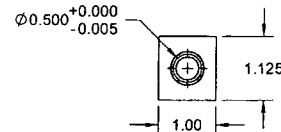
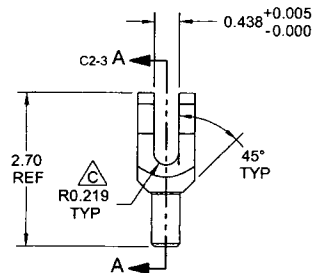
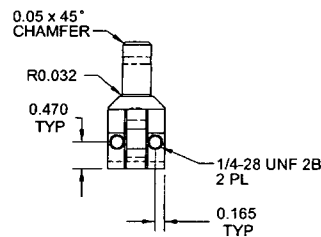
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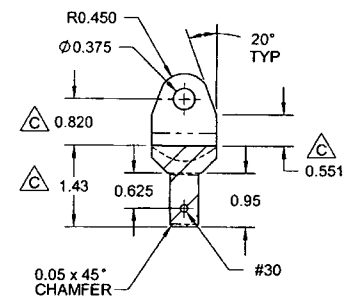
NOTE: Date & initial all entries



D3443-1 LUG





D3443-3 CLEVIS



SECTION A-A C4-3

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

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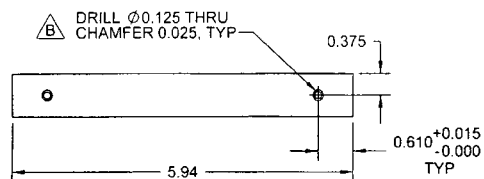
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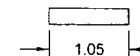
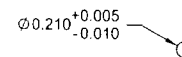
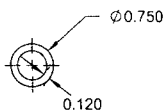
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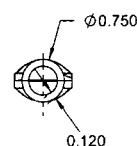
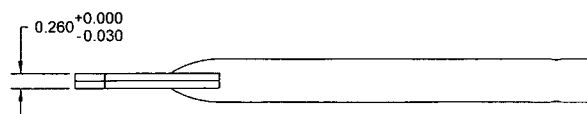
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D3443-5 TUBING

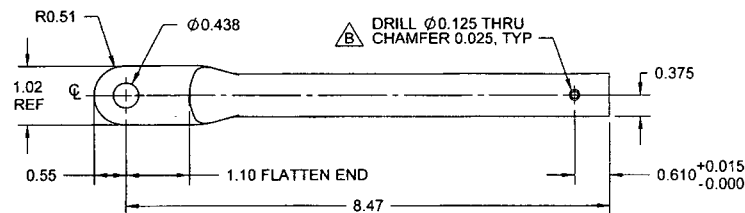


D3443-9 PIN



D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

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07/25/25

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	RF	DRAWING NO. D3443	REV. C
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